

Work Order ID 78484

78484

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January-10-12 10:15:31 AM

Item ID: D206-628-021

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Heli-Access-Step LH

Stop

NS2

Start Date: 1/10/12 Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/13/12 Req'd Qty: 2.00

2

Customer:

Reference: **Rework**

Approvals: Process Plan: *W*

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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IIN-D206-628	G
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100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels as per PPP D206-628-021 CHG 003

101

101

HandFinish

Hand Finishing

Memo

0.00

PULL FROM STOCK:
2 X D206-628-021BL B71054

STRIP STEPS COMPLETELY

102

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

102

Powdercoat

Powder Coating

Memo

0.00

POWDER COAT WHITE

CHG 003

M/L 12-01-18

*Start Time: 8:00
Temp: 3200F
Finish Time: 8:30
M-L
12/01/23*

W 12-01-25 (2)

78484.

78484.

DART Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY ON CANADA K6A 1K7				TC APPROVAL #09-89 TEL: 1-613-632-5200	
P/N	D206-628-021BL	CHG	CHG003		
DESC.	Heli-Access-Step LH	STC	SH98-14		
LOT	B71054	STC	SA00500SE		
MODEL	206L/L1/L3/L4	STC			
MADE IN CANADA				02725-1	

DART Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY ON CANADA K6A 1K7				TC APPROVAL #09-89 TEL: 1-613-632-5200	
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Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step LH

Start Date: 1/10/12 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 1/13/12 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
103	QC3- Inspect Part Finish	0.00							
103									
QC	Memo	0.00							
Quality Control									
104		0.00							
104									
HandFinish	Memo <i>KATCH. 12/1/25.</i>	0.00							
Hand Finishing	RE-WINGWALK A/R								
105		0.00							
105									
QC	QC3 Memo	0.00							
Quality Control									

2 BL 12-1-23.

2 BL 12-1-23.

*2 hM d H 12/01/23
COUNTED & MEASURED*

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 1/10/12 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 1/13/12 **Req'd Qty:** 2.00 ***~***

Customer:

Reference:

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID	Tool #
---------	--------

Plan Code	Accept Qty
--------------	---------------

Reject
Qty

Reject Number	Insp. Stamp
------------------	----------------

Pick Kit

0.00

110

Packaging

Packaging

Memo

RETURN TO STOCK:

8 X D2731-7 BLUE B

8 X D3394-043 BLUE-B

ADD NEW WHITE LUGS TO KITS:

8 X D2731-7 B 75078

8 X D3394-043 B 74493

0.00

D3394-043

b2731-7

B69180

B69177 (8)

12/1/25 (24)

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Quality Control

Memo

0.00

12 01 25 (2)

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Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step LH

Start Date: 1/10/12 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 1/13/12 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	REPACKAGE USING NEW B/N								
	Identify and pack for shipping as per PPP D206-628-021								
	Location: _____								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

12/12/11

12/2/11

MF
12-02-01

Picklist Print

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Work Order ID: 78484

Parent Item: D206-628-021

Parent Item Name: Heli-Access-Step LH

Start Date: 1/10/12

Required Date: 1/13/12

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:D as per ECN 766 JLM
IPP Rev:E as per ecn 1118 DD verified by:EC
NAS1149D0463J DD verf by:EC
IPP Rev:F 11.09.15 added

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-14A Bolt		Purchased	No			120	Each	124.0000	4	1117872 ⁸			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST357		103							
				118706		3							
				119798		100							
				ST358		21							
				119449		21							
AN4-15A Bolt		Purchased	No			120	Each	17.0000	8	1117423 ¹⁶			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST358		17							
				118706		17							
D206-628-021BL Heli-Access-Step LH, Blue		Manufactured	No				Each	2.0000	2				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG114		2							
				71054		2							
D2731-7 Blue return to stock Mounting Lug		Manufactured	No				Each	54.0000	2	11177 ⁸			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST468A		4							
				71860		4							
				ST469		50							

Picklist Print

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Work Order ID: 78484

Parent Item: D206-628-021

Parent Item Name: Heli-Access-Step LH

Start Date: 1/10/12

Required Date: 1/13/12

Start Qty: 2.00

Required Qty: 2.00

D2731-7 New Manufactured No 120 Each 54.0000
Mounting Lug

4 B75078 SI

Location	Loc Qty	Loc Code
ST468A	4	
71860	4	
ST469	50	

D2732-030 original Manufactured No 120 Each 4.0000
Rubber Cushion

8 16

Location	Loc Qty	Loc Code
ST402	4	
64283	4	

D3394-043 Blue return to stock Manufactured No
Lug Assembly

10 8x8 2x 2x 4x 4x
B69180 B75078 B75078

Location	Loc Qty	Loc Code
ST479	27	
74493	27	

D3394-043 New Manufactured No 120 Each 27.0000
Lug Assembly

4 8

Location	Loc Qty	Loc Code
ST479	27	
74493	27	

MS21042L4 original Purchased No 120 Each 7,915.0000
Nut

12 12/1/23 24

Location	Loc Qty	Loc Code
ST300	7915	
117441	51	
117601	342	
118451	133	
119017	2389	
119075	5000	

24

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Shop Packet Print

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Picklist Print

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Parent Item: D206-628-021

Parent Item Name: Heli-Access-Step LH

Start Date: 1/10/12

Required Date: 1/13/12

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0463J

Purchased

No

120

Each

6,718.0000

12

Washer

original

ml 8/17/12

SP

Location

Loc Qty

Loc Code

ST298

6718

116289

16

116805

0

117291

1

117460

2

118179

42

118384

170

118612

3

119042

11

119075

6304

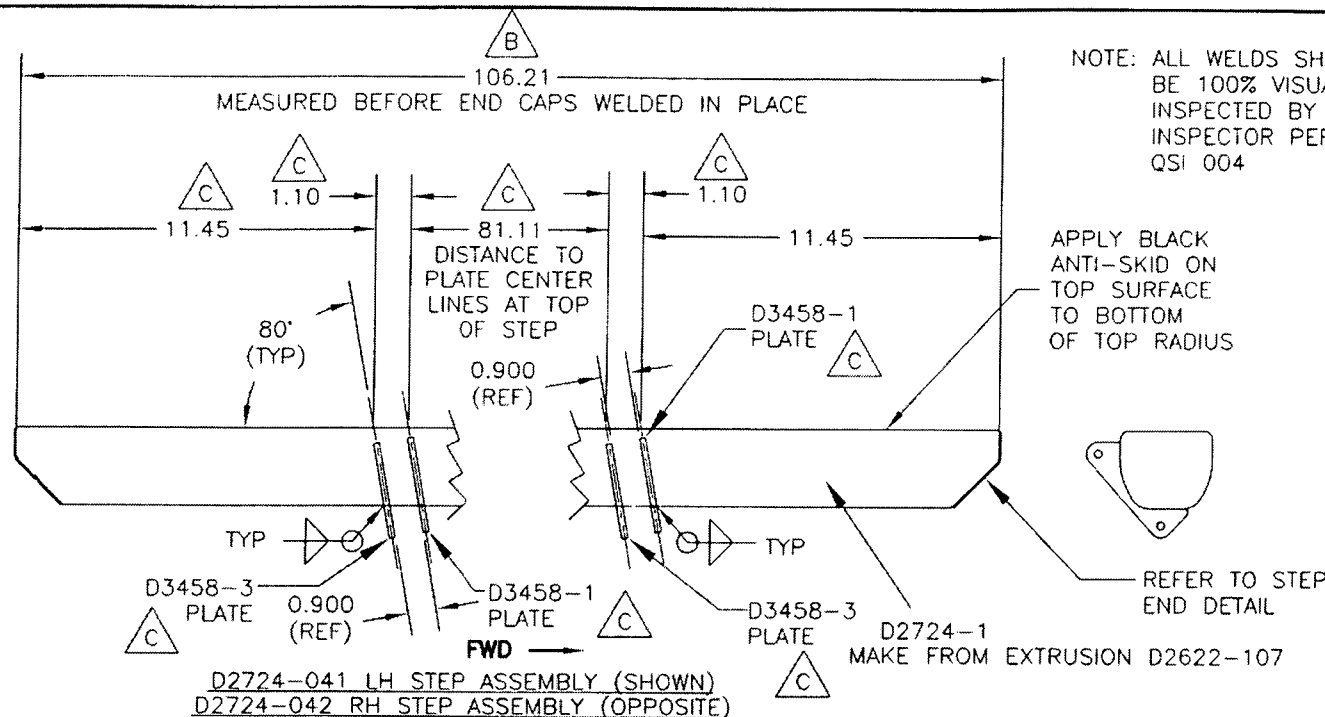
119097

169

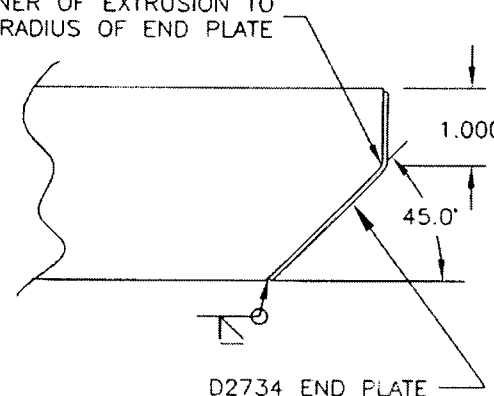
DART

RELEASED
05.11.14

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004



ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.09.19	TITLE	D2724	RE-DESIGN, ADD D3458-1/-3
			206L/407 STEP ASSEMBLY	
			NEW ISSUE	
			UPDATED WELD DETAIL REVISED TOLERANCES	
			SCALE	
			NTS	
			SHEET 1 OF 1	
			REV. C	

